

**Work Order ID 63890**

Thursday, November 18, 2010 11:02:43 AM



ASAP

Page 1

Item ID: D4014-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Switch Plate

Start Date: 11/18/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 11/23/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: MP Date: 10-11-18 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4014	A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.00

B10-11-18

E510/11/22

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B10-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63890**

Thursday, November 18, 2010 11:02:43 AM

Page 2

Item ID: D4014-1

Accept

Revision ID:

Item Name: Switch Plate

Start Date: 11/18/2010 Start Qty: 8.00

Required Date: 11/23/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

5 10/11/22

713

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

7 el 10/11/22

113

Hand Finishing

151

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

M 11/25/88

Start Time: 12:00  
Oven Temperature: 320°  
Finish Time: 12:30

13

11/10-11-22

Powder Coating

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 63890

Thursday, November 18, 2010 11:02:43 AM



Page 3

Item ID: D4014-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Switch Plate					
Start Date: 11/18/2010	Start Qty: 8.00		Cust Item ID:		
Required Date: 11/23/2010	Req'd Qty: 8.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				13	0		
170 	Identify as per dwg & Stock Location: <u>57114</u>	0.00							
Packaging Packaging	Memo	0.00							
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/11/24 (13)

10/11/24 MF  
10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, November 18, 2010 11:02:42 AM

Page 1

Work Order ID: 63890



Parent Item: D4014-1



Parent Item Name: Switch Plate

Start Date: 11/18/2010

Required Date: 11/23/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 09.12.18 new Issue Prelim EC verified: DD IPP Rev:B  
10.05.17 as per ECN10-562 DD verf:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	57.9200	0.007	0.058947			
6061-T6 Sheet 0.032"													



11-18-10

Location

Loc Qty

Loc Code

MAT21

57.92

110063

3

112763

41.12

16954

7.9

18375

5.9

16954

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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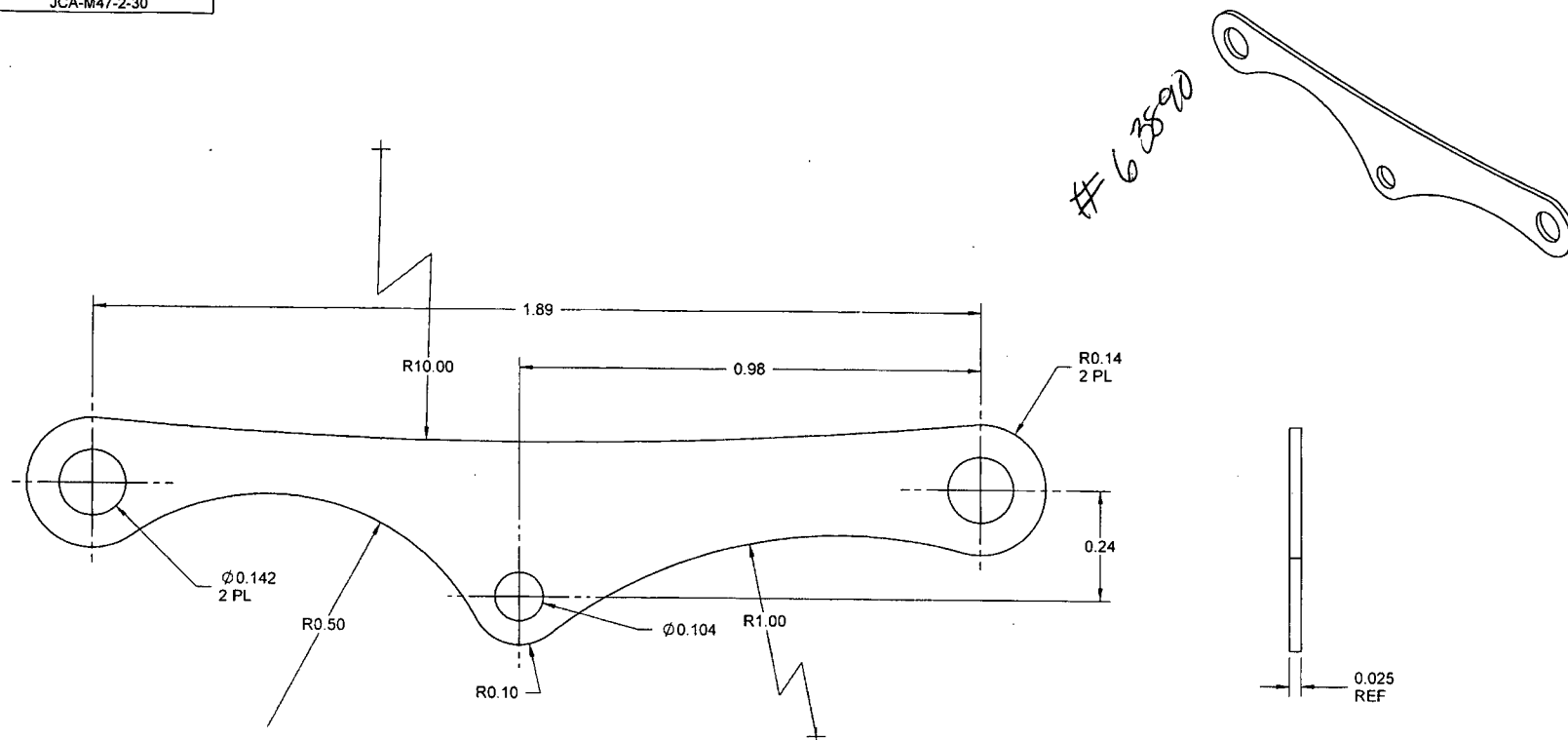


<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	63890
<b>Description:</b> Switch Plate		<b>Part Number:</b>	D4014-1
<b>Inspection Dwg:</b> D4014 <b>Rev:</b> A		<b>Page 1 of 1</b>	

[illegible]

Measured by: JB	Audited by: [Signature]	Preliminary Approval: N/A
Date: 10-11-18	Date: 10/11/22	Date: N/A

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4014-1	JCA-M47-2-30



**D4014-1 SWITCH PLATE**

**RELEASED**  
2010-05-05  
MD

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.025 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.025
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.00 lbs

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.03.11			

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4014</b>	REV. A
TITLE <b>COVER</b>	SCALE NTS
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**NOTE:** Date & initial all entries

## David Duval

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**From:** Harvey Siemens [hsiemens@dartaero.com]  
**Sent:** November 18, 2010 11:11 AM  
**To:** 'David Duval'  
**Cc:** 'Mike Petsche'; 'Eric Charbonneau'  
**Subject:** D4014-1 deviation

David

It is acceptable to make the D4014-1 from 0.032" thick material instead of the 0.025" material specified in the drawing.

Regards,

*Harvey Siemens*

Mechanical Designer  
**DART** Aerospace Ltd.

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